+135-3858-6433 (GuangDong)
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AKRO COMPOUNDS

Compound No.: **8820**

AKROMID® PRELIMINARY
A3 GF 30 9 FR black (8820)

PA66 GF30 FR(40)

AKROMID®A3 GF 30 9 FR black (8820) is a 30 % glass fibre reinforced, flame-retardant and heat-stabilized PA6.6, coloured in black similar to RAL 9005. The material is based on a flame retardant system that is free of red phosphorus, halogens, PFAS, zinc borate and melamine. This grade has a V0 classification from a wall thickness of 1.6 mm and is characterized by high flowability and beautiful surfaces.

Features

heat stabilised 130 | electrically neutral | flame retardant | surface modified | easy flow | process improved | E&E | E-Mobility

Properties

Modulus	Strength	Impact
10.500 MPa	**150** MPa	**65** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min | d.a.m. 1 mm/min | conditioned	**10500 MPa** **7200 MPa**
Tensile stress at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**150 MPa** **105 MPa**
Tensile strain at break ISO 527-2	5 mm/min | d.a.m. 5 mm/min | conditioned	**2,5 %** **4,5 %**
Charpy impact strength ISO 179-1/1eU	23°C | d.a.m. 23°C | conditioned	**65 kJ/m²** **65 kJ/m²**
Charpy notched impact strength ISO 179-1/1eA	23°C | d.a.m.	**10 kJ/m²**

Thermal Properties

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Temperature of deflection under load HDT/A ISO 75	1,8 MPa	**246 °C**
Melting temperature ISO 11357-3	DSC, 10K/min	**262 °C**

Flammability

Flammability UL 94	1,6 mm Wall thickness	**V0 Class**
	3,2 mm Wall thickness	**V0 Class**

General Properties

Density ISO 1183	23°C	**1,37 g/cm³**
Humidity absorption ISO 1110	70°C, 62% r.H.	**1,9 - 2,1 %**
Molding shrinkage ISO 294-4	flow	**0,1 - 0,3 %**
	transverse	**0,7 - 0,9 %**

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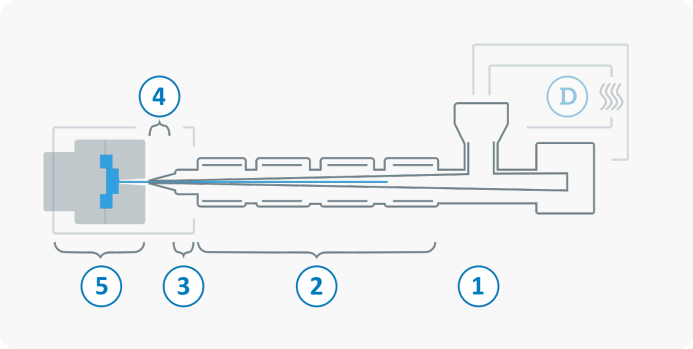
Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	2 - 4 h
	Drying temperature (τ <= -30°C)	80 °C
	Processing moisture	0,02 - 0,08 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	260 - 290 °C
3	Nozzle temperature	260 - 300 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	60 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 100 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min